

Date: Friday, 18/07/2008 1:10:54 PM
 User: Julie Lecocq

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : SEAT SUPPORT ASSEMBLY, LH
 Job Number : 40660
 Estimate Number : 13328
 P.O. Number :
 This Issue : 18/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL / MED FAB
 Previous Run : 05010
 Written By :
 Checked & Approved By : JUL 08.7.18
 Comment : Est Rev:A 08-05-19 new issue DD verified by:ec
 Est Rev:B 08-07-18 revB as per dwg DD verified by:EC

Part Number : D3784043
 Drawing Number : D3784 REV B
 Project Number :
 Drawing Revision : B
 Material :
 Due Date : 06/08/2008 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0 D3763043 End Fitting Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 End Fitting Assembly, LH
 batch: 40685

No Qty

SAN 08/08/12

(2)

3.0 D37701 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Tube
 batch: B40713

No Qty's

SAN 08/08/12

(2)

4.0 D37703 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Tube
 batch: B40714

No Qty's

SAN 08/08/12

(2)

5.0 D3763041 End Fitting Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
 End Fitting Assembly
 batch: 40684-10

No Qty's

SAN 08/08/12

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 1:10:54 PM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: SEAT SUPPORT ASSEMBLY, LH

Job Number: 40660

Part Number: D3784043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch:

M104885

(or NAS1149Do332J) batch:

JS 08/08/01 (x2)

7.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch:

M107065

JS 08/08/01 (x2)

8.0

AN52510R20

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch:

M108559

JS 08/08/01 (x2)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3784

****Note 8: Hole "A" is located 5" from the end of D3770-3 tube and must be oriented up****

****Note 8: Hole "B" is located 5" from the end of D3770-1 tube and must be oriented AFT****

SAD 08/08/12

(2)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/08/13 (x2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock

Location: A

JS 08/08/13

(2)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JS 08/08/14

(2)

Job Completion



MF 08-08-13

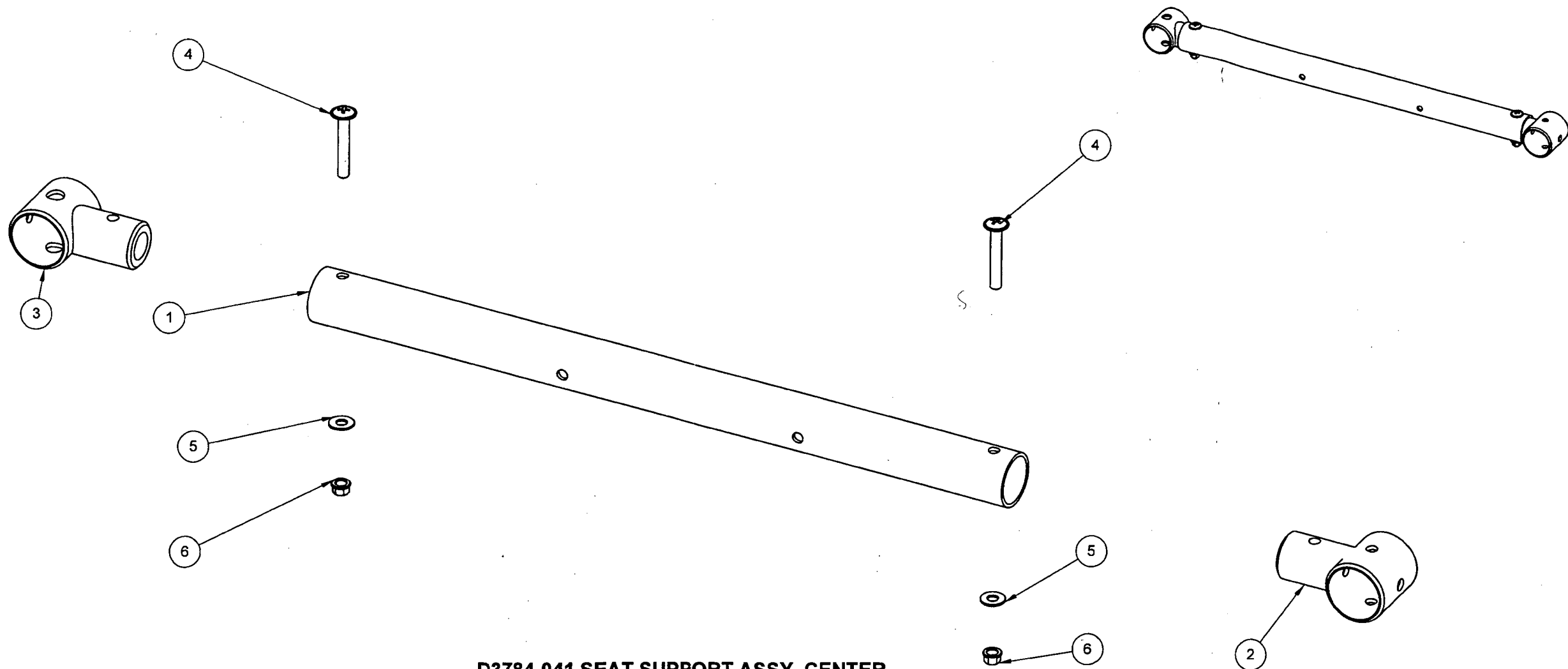
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3784-041 SEAT SUPPORT ASSY, CENTER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3770-1	TUBE	1
2	D3763-041	END FITTING ASSY	1
3	D3763-045	END FITTING ASSY	1
4	AN525-10R20	SCREW	2
5	NAS1149D0332J	WASHER (AN960JD10L)	2
6	MS21042L3	NUT	2

B
 B
 B
 B

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

B	HARDWARE CHANGE, ASSY CHANGE	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3784	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	SEAT SUPPORT ASSEMBLY	NTS
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 NO. 40610

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 08.07.10

8 7 6 5 4 3 2 1

D

D

C

C

B
B
B

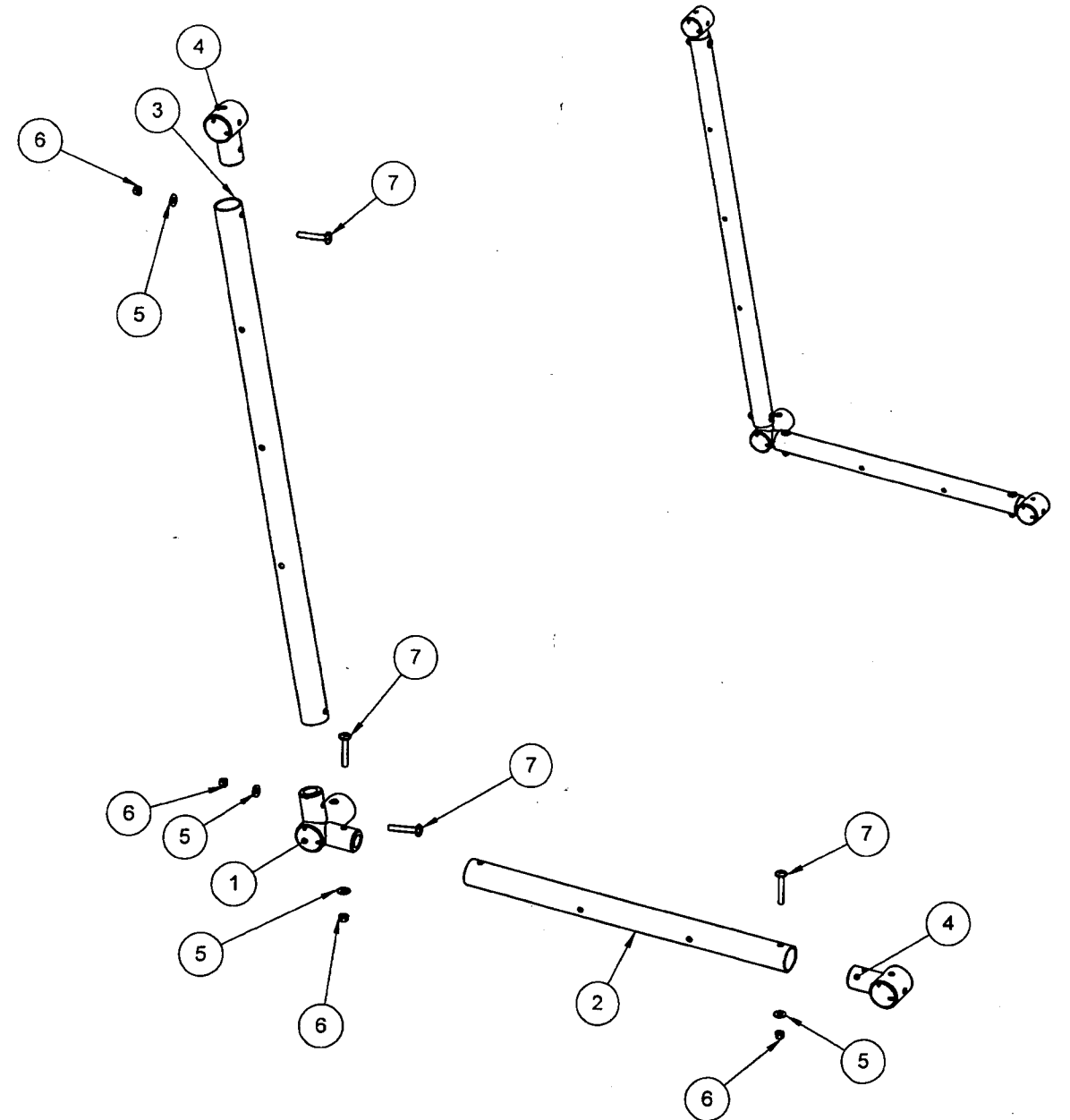
B

B

A

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	MS21042L3	NUT	4
7	AN525-10R20	SCREW	4



D3784-043 SEAT SUPPORT ASSY, LH

NOTES:

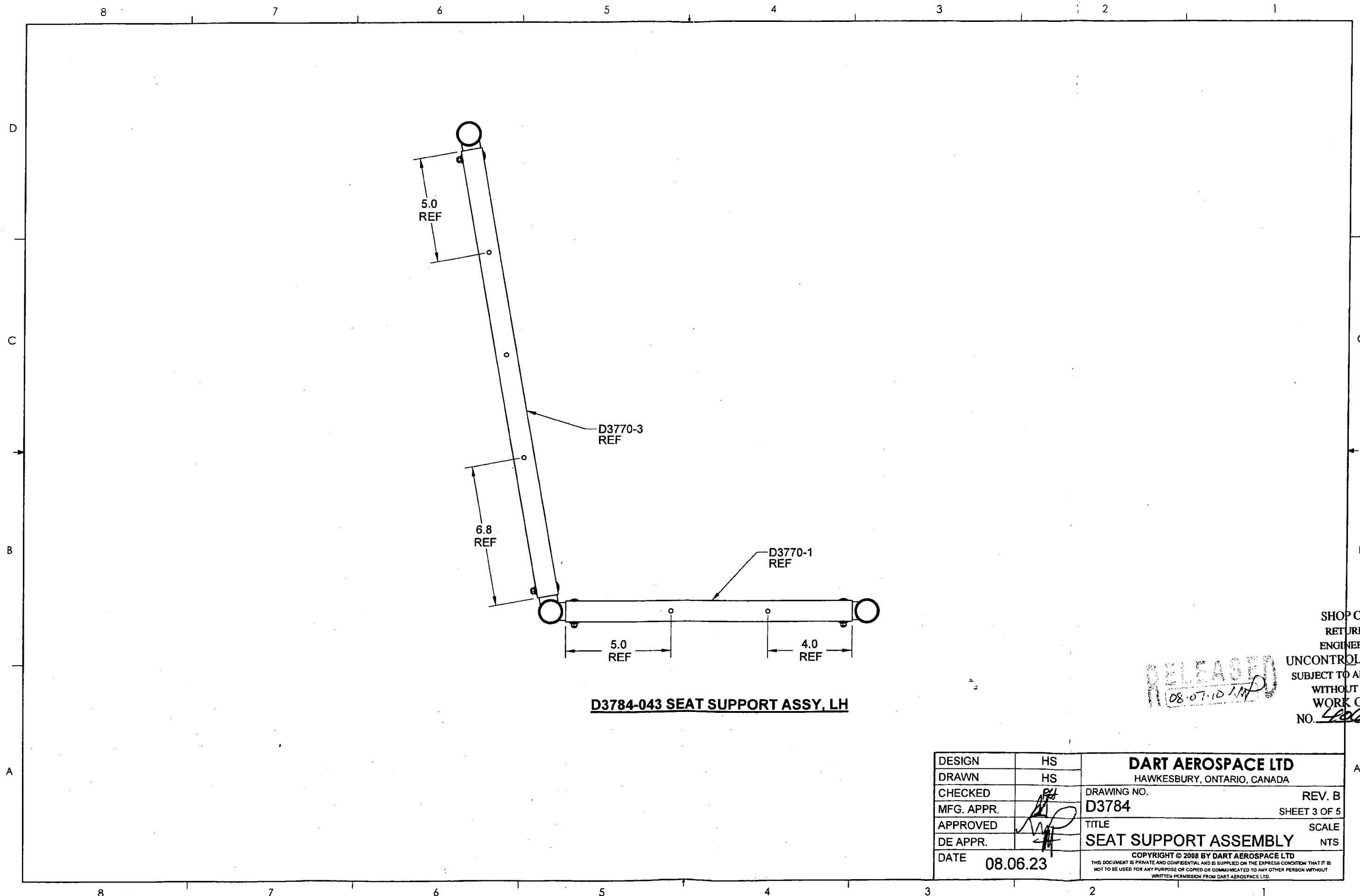
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

8 7 6 5 4 3 2 1

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DRAWN	HS	
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MFG. APPR.	MA	REV. B SHEET 2 OF 5
APPROVED	MA	TITLE SEAT SUPPORT ASSEMBLY
DE APPR.	MA	SCALE NTS
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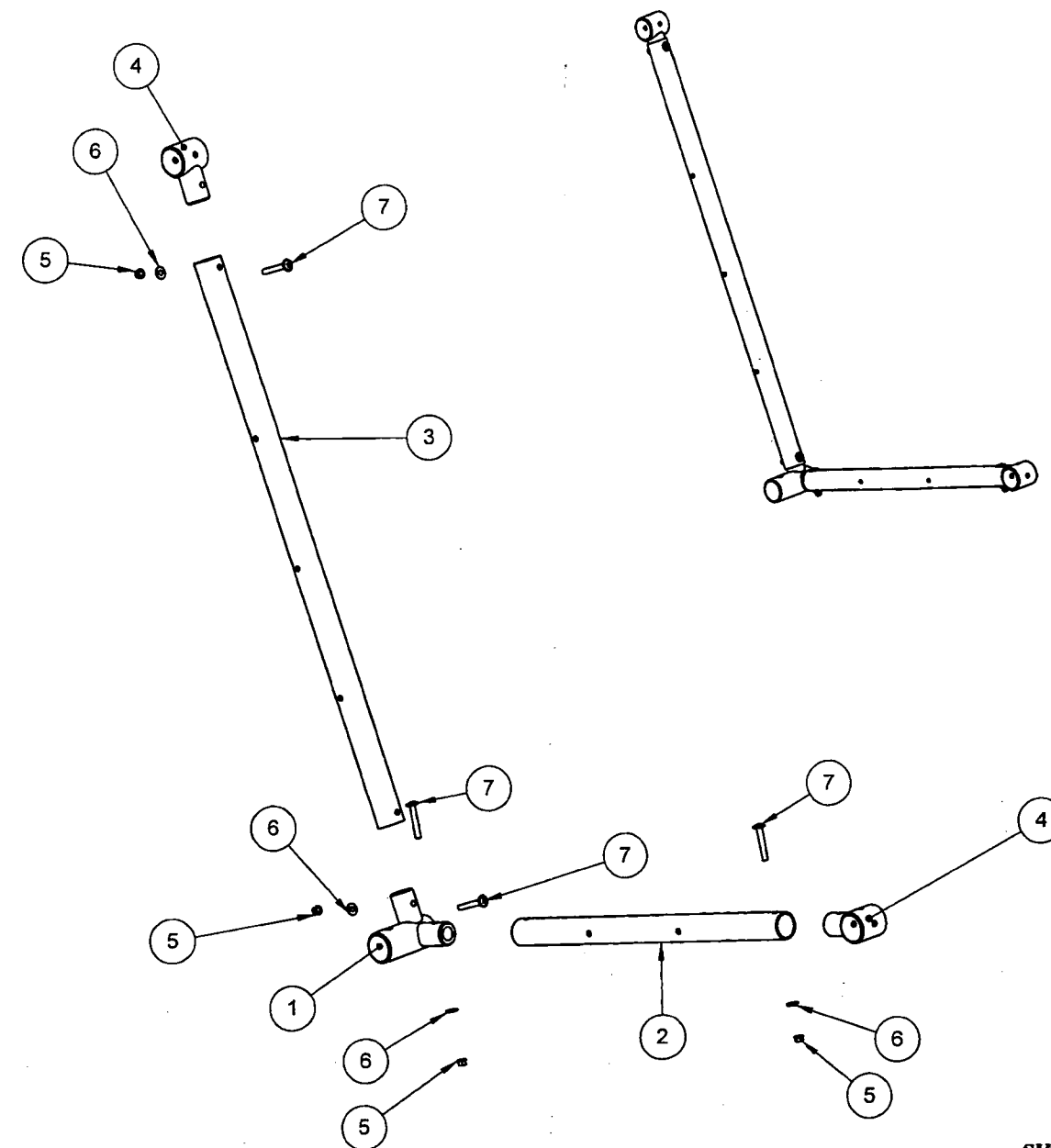
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MFG. APPR.	MP	D3784	SHEET 3 OF 5
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4

△
B
△
B
△
B



D3784-044 SEAT SUPPORT ASSY, RH

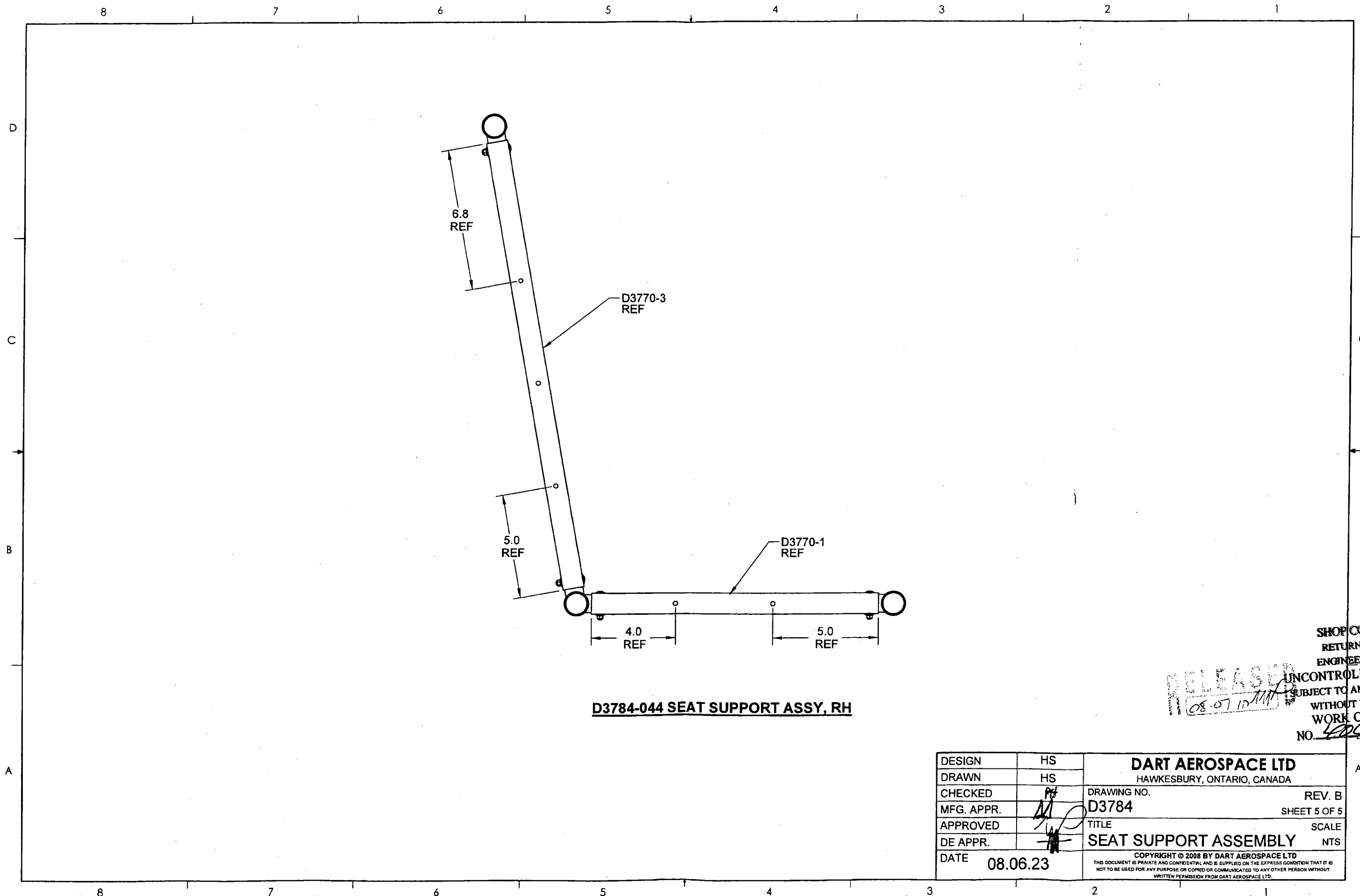
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
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MFG. APPR.	<i>[Signature]</i>	REV. B SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE SEAT SUPPORT ASSEMBLY
DE APPR.	<i>[Signature]</i>	SCALE NTS
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